



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-4-OH
Job Sheet 175469



Part No: SWA10A-4-OH

Job Qty: 1 ea

Part Name: Electric Swivel 10,000 lb Safe Work Load (4,536 kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No: RA203 - CNAM1068-02

Due Date: 4/6/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG SWA10A Rev 3 IPP Rev A 18.03.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	4/5/18	4/5/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs	4/5/18	4/5/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs	4/5/18	4/5/18	0.00	0.00	QC5		
170	Small Fab	1 pcs	4/6/18	4/6/18	0.00	1.00	Small Fab-9		
180	QC	1 pcs	4/6/18	4/6/18	0.00	0.00	QC5		
185	DC	1 pcs	4/6/18	4/6/18	0.00	0.00	DC		
190	Packaging	1 pcs	4/6/18	4/6/18	0.00	0.00	Packaging3-2		
200	QC21-FG	1 Ea	4/6/18	4/6/18	0.00	0.00	QC21		

Part Op 110 - TEST ASSEMBLY. DISASSEMBLE ASSEMBLY. INSPECT DAMAGE PART.

Descriptions: 170 - RE-ASSEMBLE. ***All assembly to be done in accordance with manual*** TEST ASSEMBLY.

185 - Photocopy blue file and create labels

APR 24 2018

Ship QA
paper w/ part



Date: 04/24/18

M dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
ate : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

002736

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA10A-4-AR	Electric Swivel 10,000 lb Safe Work Load (4,536 Kg)	1 pcs (1 ea)	100-Start up Operation	
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	170-Small Fab	5037083
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	170-Small Fab	5027240
C10-28	Swivel Bushing, C10/SWA10	1 Ea (1 ea)	170-Small Fab	5033023
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	170-Small Fab	5058761
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	170-Small Fab	5054451
EL414-ARTIC	4 Wire	6 ft (6 ea)	170-Small Fab	5047764
SWA10A-100	Lower End	1 Ea (1 ea)	170-Small Fab	
SWA10A-1100	Upper DU Bearing	1 Ea (1 ea)	170-Small Fab	
SWA10A-1200	Lower DU Bearing	1 Ea (1 ea)	170-Small Fab	5057597
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	170-Small Fab	5047196
SWA10A-1400	Circlip	1 Ea (1 ea)	170-Small Fab	5036191
SWA10A-1800	Cover	1 Ea (1 ea)	170-Small Fab	
SWA10A-200	Upper End Swivel	1 Ea (1 ea)	170-Small Fab	
SWA10A-300	Bearing Housing	1 Ea (1 ea)	170-Small Fab	
SWA10A-400	Thrust Washer	1 Ea (1 ea)	170-Small Fab	5049928
SWA10A-500	Semi-Rings	1 Ea (1 ea)	170-Small Fab	
SWA10A-600	Collar	1 Ea (1 ea)	170-Small Fab	
SWA10A-700A	Wire Clamp	2 Ea (2 ea)	170-Small Fab	
SWA6A-1900	Female Spade Terminal - 1/4"	4 Ea (4 ea)	170-Small Fab	5054299
SWA6A-2000	1/8" Female Spade Connector	4 Ea (4 ea)	170-Small Fab	5047604
SWA6A-800B	Connector Bushing	1 Ea (1 ea)	170-Small Fab	
SWA6A-900C	Rotary Contact	1 (1 ea)	170-Small Fab	

GREASE 7 BATCH : M138724 / LOCTITE 620 BATCH M138764

Job Allocations

LOCTITE 242 BATCH/M138764 2

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	SWA10A-4	1	0	0
170-Small Fab	188-FPSS-1032-5/8	1	387	0
	188-FSCS-1032-5/8	4	196	0
	C10-28	1	7	0
	EL-PLUG-F	1	28	0
	EL-PLUG-M	1	53	0
	EL414-ARTIC	6	353	0
	SWA10A-100	1	0	0
	SWA10A-1100	1	0	0
	SWA10A-1200	1	22	0
	SWA10A-1300	1	25	0
	SWA10A-1400	1	20	0
	SWA10A-1800	1	8	0
	SWA10A-200	1	0	0
	SWA10A-300	1	8	0
	SWA10A-400	1	19	0
	SWA10A-500	1	0	0
	SWA10A-600	1	10	0
	SWA10A-700A	2	30	0
	SWA6A-1900	4	292	0
	SWA6A-2000	4	80	0
	SWA6A-800B	1	0	0
	SWA6A-900C	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Inspection Sheet Complete RA203

Customer QA Ref #										0
Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order instructions	
SWA10A-4	CNAM1068-02	#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes	CUSTOMER SUPPLIED	S043993	Customer supplied part. Customer sending SWA10A-4 serial# CNAM1068-02 to be overhaul Preform overhaul and return to customer	
0		#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes				
0		#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes				
0		#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes				
0		#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes				
0		#VALUE!	☐ yes	☐ yes	☐ yes	☐ yes				

QC Approval: P.D. _____

Date: 18-Mar-18 _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Inspection Sheet Complete

RA203

Customer QA Ref #

0

Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order Instructions
SWA10A-4	CNAM1068-02	#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes	CUSTOMER SUPPLIED	S043993	Customer supplied part. Customer sending SWA10A-4 serial# CNAM1068-02 to be overhaul Preform overhaul and return to customer
0		#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		#VALUE!	☐ Yes	☐ Yes	☐ Yes	☐ Yes			

QC Approval: P.D. _____

Date: 18-Mar-18 _____

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO35580	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039522
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

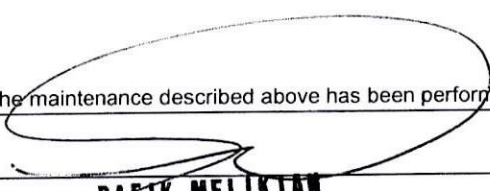
CARRY OUT NDT ON:

2 ELECTRIC SWIVEL 3000lb , P/N# SWA3-3-OH , J/S# 173678 , 175468

1 ELECTRIC SWIVEL 10,000 lb , P/N# SWA10A-4-OH , J/S# 175469

Action Taken:						Date:	Initial/Stamp:
MPI C/O IAW ASTM E-1444M-12 ***NO CRACK FOUND*** MAGBENCH S/N 208123 CAL DUE: 23-JUL-2018 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165						APR 09 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp	Date:
Name: RAFIK MELIKYAN		APR 09 2018

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO35580	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039522
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

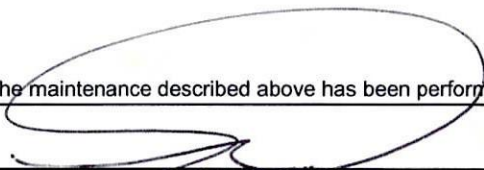
CARRY OUT NDT ON:

2 ELECTRIC SWIVEL 3000lb , P/N# SWA3-3-OH , J/S# 173678 , 175468

1 ELECTRIC SWIVEL 10,000 lb , P/N# SWA10A-4-OH , J/S# 175469

Action Taken:						Date:	Initial/Stamp:
MPI C/O IAW ASTM E-1444M-12 ***NO CRACK FOUND*** MAGBENCH S/N 208123 CAL DUE: 23-JUL-2018 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165						APR 09 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: APR 09 2018
Name: RAFIK MELIKYAN		



Electric Swivel

SWA10A

Work Order

175469

Customer

Number of Wires

4

Date

2018/04/23

Serial Number

CNAM 1068-02

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	10,000	Check for Conductivity against all wires.	PASS
1	10,000	Check all wires for grounding against swivel body.	PASS
1	5,000	Check for Conductivity against all wires.	PASS
1	5,000	Check all wires for grounding against swivel body.	PASS
1	2,500	Check for Conductivity against all wires.	PASS
1	2,500	Check all wires for grounding against swivel body.	PASS
1	0	Check for Conductivity against all wires.	PASS
1	0	Check all wires for grounding against swivel body.	PASS

Test Conducted By:

ALAIN PATRY

Technician

Signature:

Sylvia Pouchet
QC / Small FAB / QA

Submit